

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019959**Date Inspected:** 24-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China

<b>CWI Name:</b>	Mr. Huang Min		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No
<b>Weld Procedures Followed:</b>	Yes	No
<b>Verified Joint Fit-up:</b>	Yes	No
<b>Approved WPS:</b>	Yes	No
<b>Delayed / Cancelled:</b>	Yes	No

**Bridge No:** 34-0006**Component:** OBG BAY 5 to 8**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 6

Flux Cored Arc (FCAW) welding of welds joint CB3002L-018-025, And Welder is identified as 062447, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2333-TC-P4-F.

FCAW welding of welds joint CB3002L-018-063, And Welder is identified as 205386, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2333-TC-P5-F.

FCAW welding of welds joint CB3002L-018-078, And Welder is identified as 051246, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-B-T-2233-TC-U5-F.

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## WELDING INSPECTION REPORT

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FCAW welding of welds joint CB3002J-001-046, And Welding Repair Report (WR)B-WR16573, Welder is identified as 053609, ZPMC Quality Control (QC) is identified as Mr. Zhong Zhi Wei. The welding variables appeared to comply with the Applicable WPS-345-FCAW-3G(3F)-Repair.

BAY #8

FCAW welding of welds joint BK004A-057-044, And Welder is identified as 054459, ZPMC Quality Control (QC) is identified as Mr. Feng Ya Jun. The welding variables appeared to comply with the Applicable WPS-B-T-2231-B-U2-F.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC Verbal Notification.

### Visual Testing (VT)

This QA Inspector performed VT of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Bike Path Anchor Hoses(Both Ends of Bike Path) welds. The weld designations reviewed are as follows.

1. BK004A3-053-065/100,068/102,067/101,069/103,070/104,071/105
2. BK004A4-053-080/100,083/102,082/101,085/103,086/104,087/105
3. BK004A3-054-065/100,068/102,067/101,069/103,070/104,071/105
4. BK004A4-054-080/100,083/102,082/101,085/103,086/104,087/105

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 07081

### Magnetic Particle Testing (MT)

This QA Inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a MT report for this date. The member is identified as Bike Path welds. The weld designations reviewed are as follows.

1. BK004A2-053-009,010,011,012
2. BK004A4-053-019,020,021,045,046,047,061,071,072,073
3. BK004A3-053-057,058,059
4. BK004A8-053-061,063,065,070,073,086,088,090,092

Note:- ZPMC QC identified as Mr. Lito canceled the above mentioned NDT notification stating "ZPMC has not completed the required percentage of MT on these joints".

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng (15921845703), who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Tharikoppada,Reddy
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Miller,Mark
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QA Reviewer
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